

Date: Monday, 7/9/2007 11:47:26 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 33371		
Estimate Number	: 12731		
P.O. Number	: N/A	Part Number	: D353535
This Issue	: 7/9/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3535 UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32736	Drawing Revision	: AB PH 07-07-09
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 7/16/2007 Qty: 20 Um: Each
Comment	: Est Rev:A New Issue 07-02-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s) HB 07-07-17 304/316 .040 Sheet (M304S20GA) Batch: M 104 640 M 103 713 M 101 873 M 101 093
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B HB 07-07-17
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 07-07-17
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. 3-Identify as D3535-35.
		FF 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/05	# 20	1 part found with 0.300x0.300 holes off centered by 0.020" R.L. hexagonal error material moved over when it was cut out after the holes.	/ OSIAUZ	make one to replace and test the non centered one to see if it fits B#M 102159	68 07.07 P	✓ 07/07/05	/ OSIAUZ	C CP 07/07/05
				Holes lined up Part S acceptably				

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33371

Part Number: D353535

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/24 (16)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 104846 Bpm- / 07-07-25

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 07/07/25

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

m-p 07/07/25

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

R1 07/07/25

Job Completion



JUL 07-07-26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

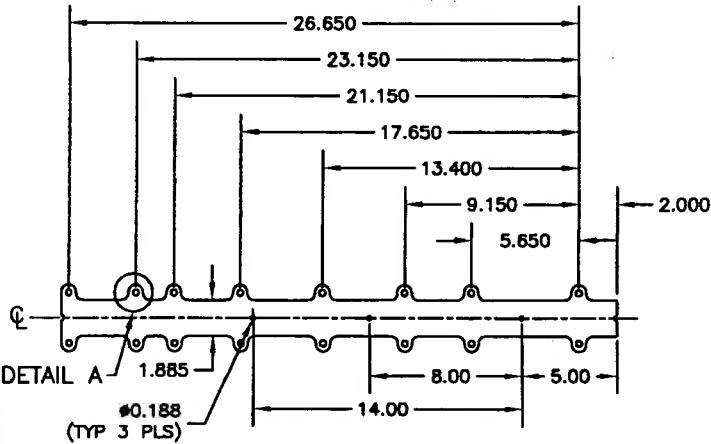
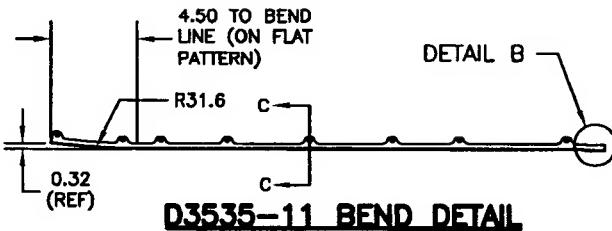
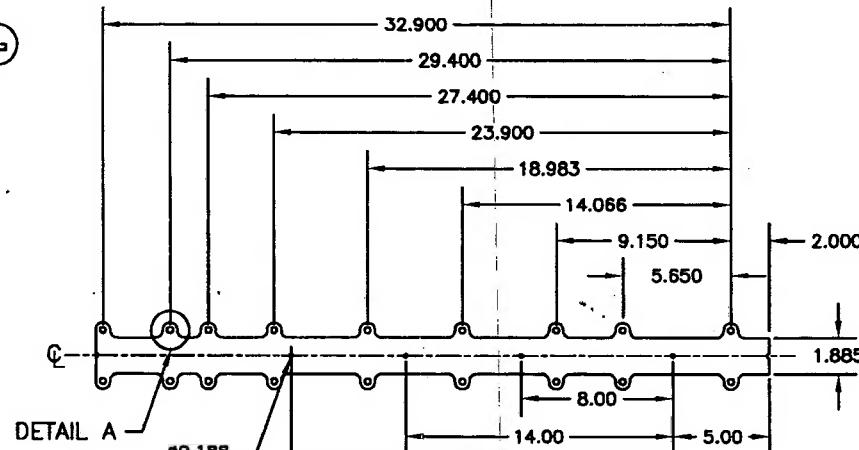
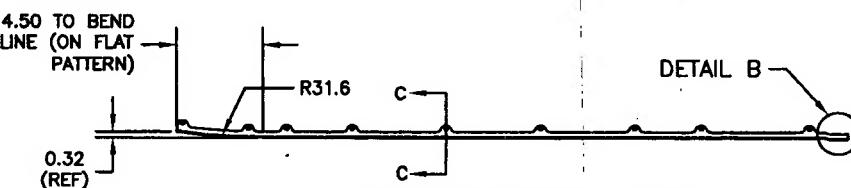
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	P.H	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
07.04.17	W.H.	D3535
DATE		TITLE
A	06.10.25	WEARSHOE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
SCALE		REV. B
1:10		SHEET 1 OF 7

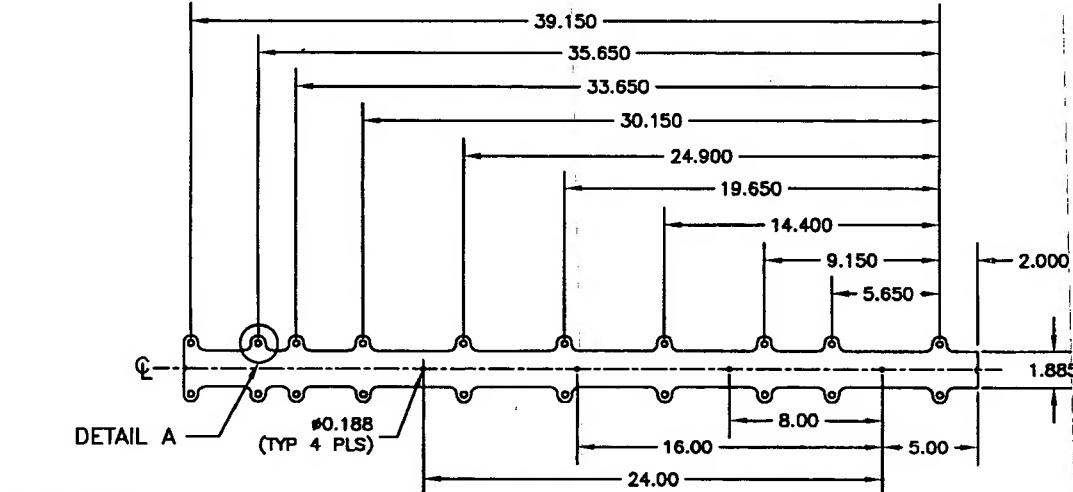
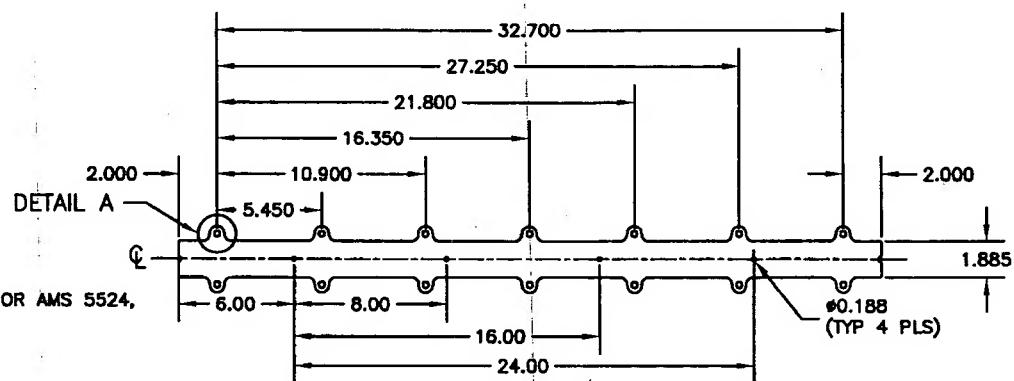
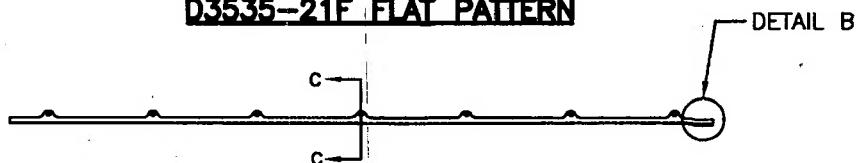
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07.04.24**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

**NOTES**

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>

**RELEASED**  
07.04.24 **PH****D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

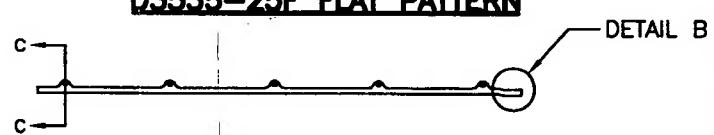
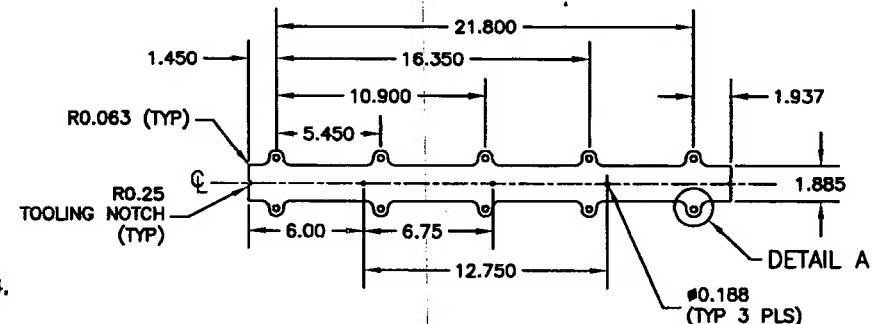
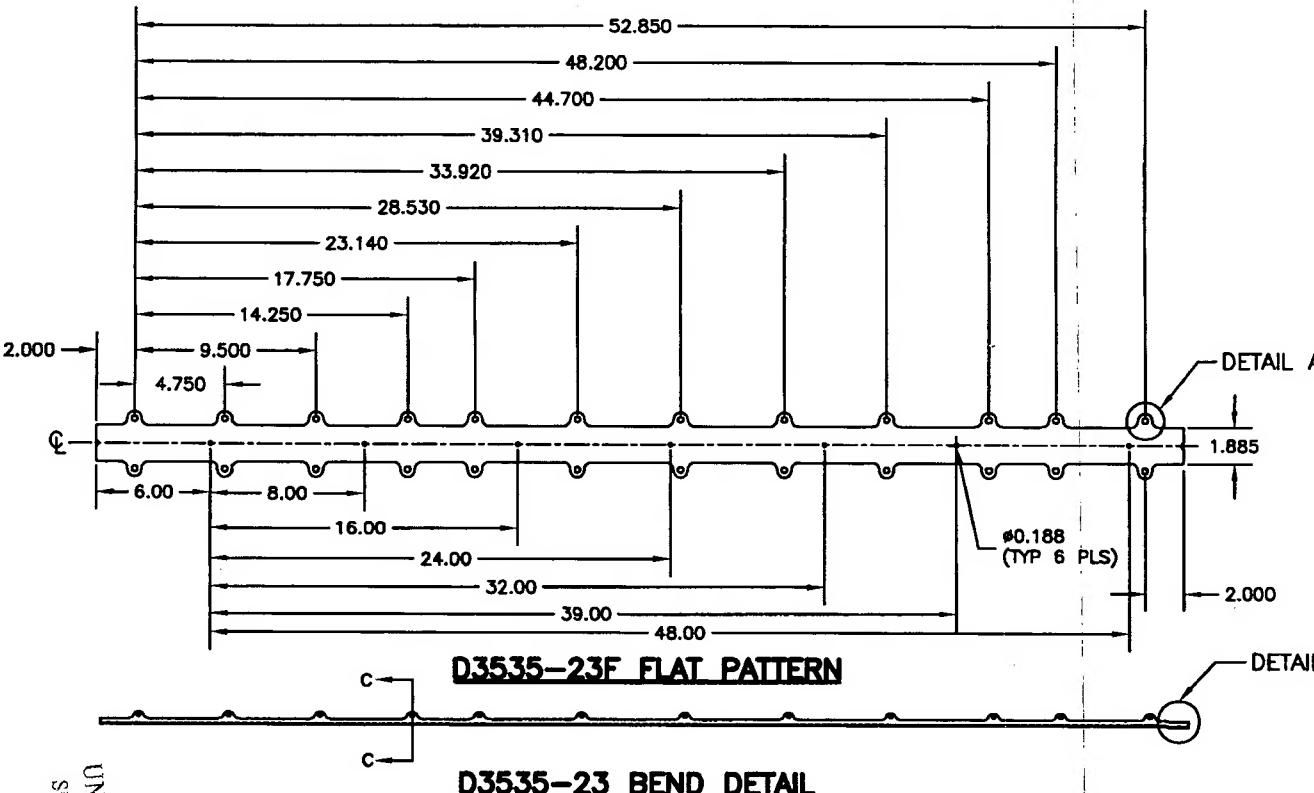
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WITHOUT NOTICE  
WORK ORDER  
NO. **33371**

**NOTES**

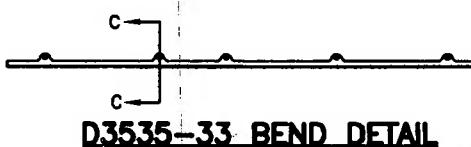
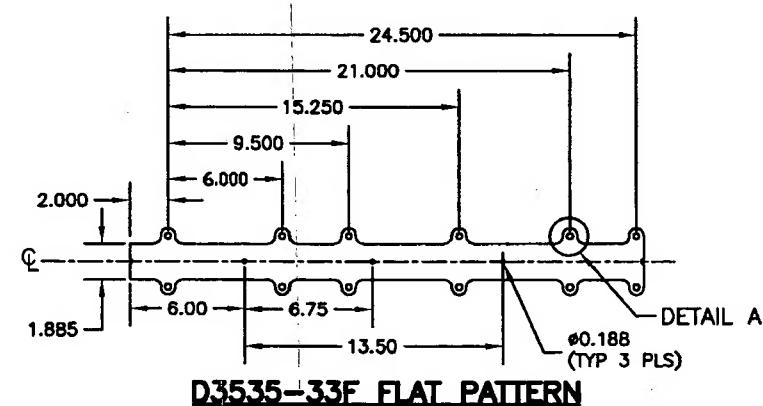
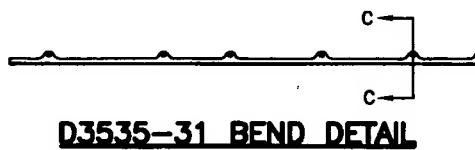
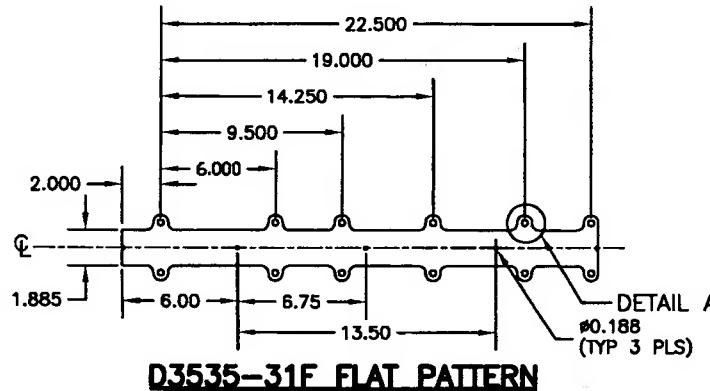
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>PW</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>M</b>	APPROVED <b>M</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>

RELEASED  
07.04.24 **M****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**RELEASED  
07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	MH	P.O.R. HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		TITLE
07.04.17		WEARSHOE

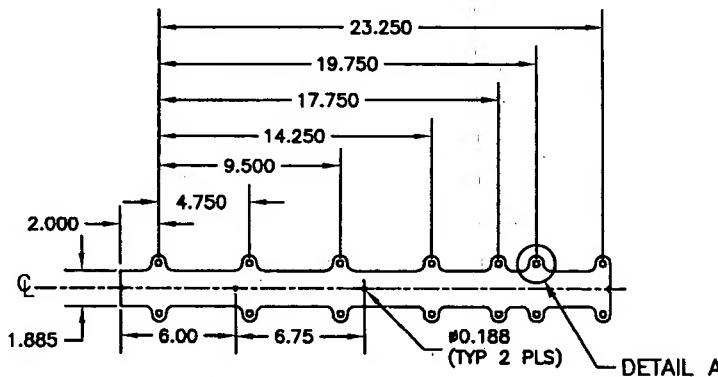
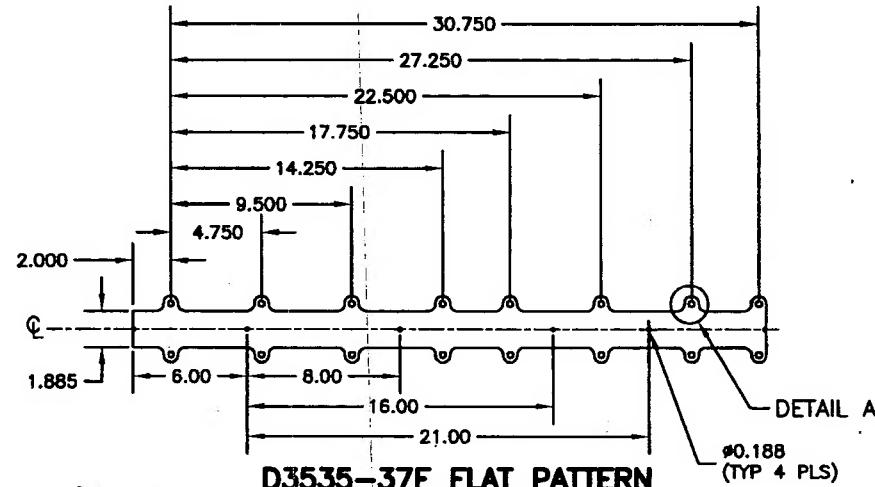
REV. B  
SHEET 4 OF 7  
SCALE 1:10

WORK ORDER  
NO. 3341  
**WIEB**  
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- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**RELEASED  
07.04.17

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>TH</b>	APPROVED <b>TH</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 5 OF 7 SCALE <b>1:10</b>

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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MARK ORDER  
NO 23371

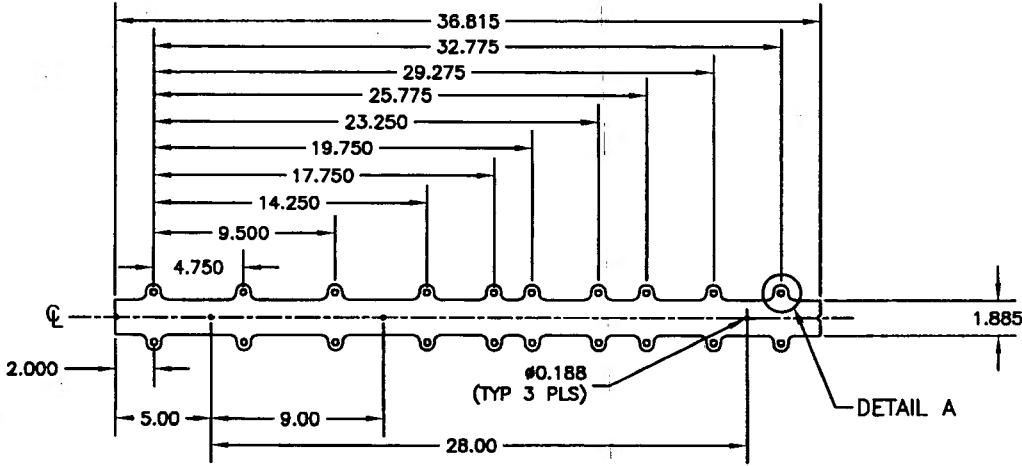
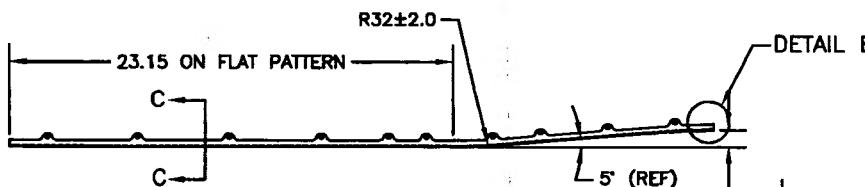
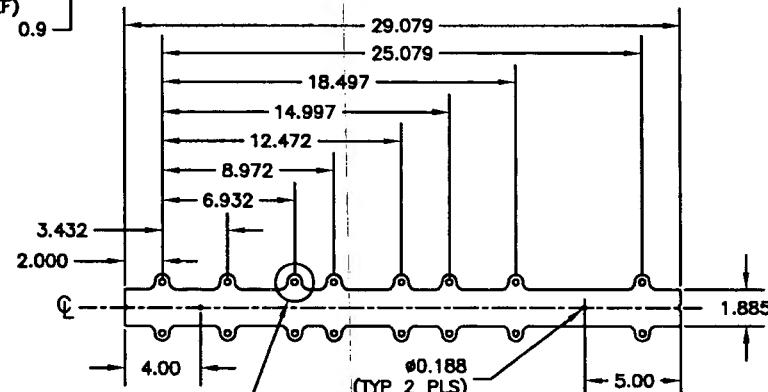
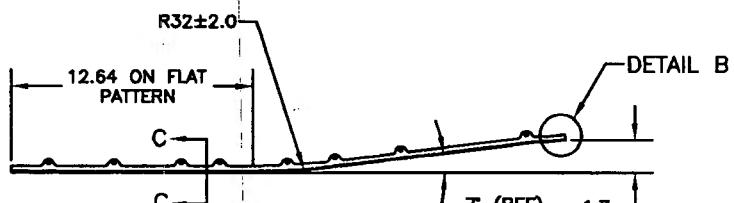
**NOTES**

- 1) MATERIAL: ANSI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

RELEASED

07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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WORK ORDER  
NO 33371

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

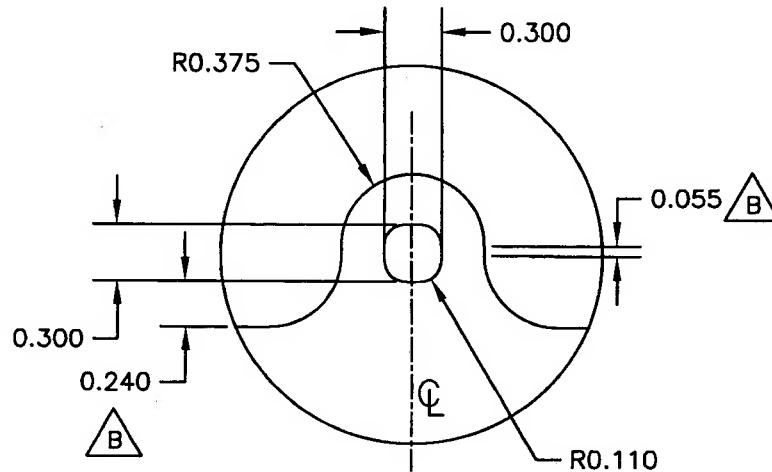
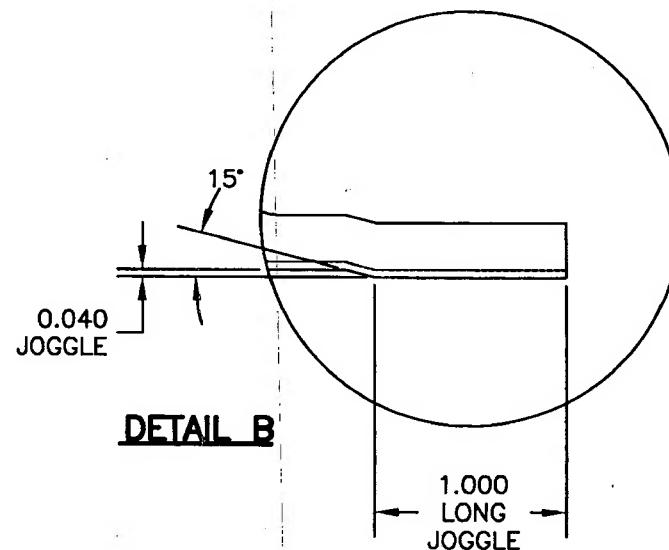
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE		TITLE
07.04.17		D3535 WEARSHOE

REV. B  
SHEET 6 OF 7  
SCALE 1:10

**DART**RELEASED  
*[Signature]*

07.04.24

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 7 OF 7 SCALE 1:1

**DETAIL A****DETAIL B****SECTION C-C**

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WITHOUT NOTICE  
WORK ORDER  
NO. 33371

DART AEROSPACE LTD	Work Order:	3337
Description: <del>W/EAR PLATE</del>	Part Number:	D 3535-35
Inspection Dwg:	Rev: B	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.250	+/- .010	23.250	*			
19.750	+/- .010	19.750	*			
17.750	+/- .010	17.750	*			
14.250	+/- .010	14.250	*			
9.500	+/- .010	9.500	Y			
4.750	+/- .010	4.750	*			
2.000	+/- .010	2.000	*			
1.885	+/- .010	1.883	*			
6.00	+/- .030	6.00	Y			
6.75	+/- .030	6.75	*			
.188	+ .006 - .001	.191	*			
.300x.300	+ .006 - .001	.303x.303	Y			

Measured by:	HB	Audited by:	ES	Prototype Approval:	
Date:	07-07-17	Date:	07/07/17	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/RF	

4